



SR Cutter User Manual

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SR Cutter 226601

Declaration of conformity

Lindab hereby declares under sole responsibility that this product complies with the following directives: 98/37/EC, 2006/95/EC, EMC 89/336/EEC.



Lars-Åke Mattsson
R&D Manager, Ventilation

Safety instructions

Read through the manual before you start using the SR Cutter. Keep the manual to hand so that everyone who uses the SR Cutter has access to the manual.

1 wear protective goggles

Risk of chips from the nibbling machine. Risk when cutting the duct's needle.

2 Use protective gloves

Risk of cut injury when handling the duct.

3 Wear ear defenders

The noise level can vary when cutting the ducts, sometimes it exceeds 85 dB(A). Always wear ear defenders to protect yourself.

4 Make sure the stand is steady

Never use the stand on uneven or unsteady surfaces. Make sure the legs are extended correctly and secured tightly before use.

5 Do not overload the stand

Do not exceed the maximum workload. Do not climb, sit or stand on the stand.

6 Do not use in a humid environment

Risk of electrical short circuit.

7 Protect the electric cable

Risk of damage to the cable from sharp plate edges.

8 Assembly and disassembly

Use the handle to make assembly easier

9 Moving

The SR Cutter must be moved on its own wheels. Avoid heavy loads.

Technical data

Bench – collapsed

Length	1910	mm
Width	500	mm
Height	380	mm

Part name	Part no
SRCS	226601
SRCS US	100584

Bench – erected

Length	1910	mm
Length (with extended telescope arms)	4800	mm
Width	730	mm
Height	1270	mm
Working height	820	mm



Maximum permitted load	75	kg
Weight	36	kg

Shears

Model	3514-7R	
Power	500	W
Voltage	230	V
Stroke frequency	2400	/min
Weight	2.2	kg



CSS EU 230	226607
CSS UK 110	226609
CSS CH 230	226608
CSS US 110	100886

Needle pliers

Length	200	mm
Weight	0.35	kg



NCP	226618
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Click pliers, small (Ø 80-224)

Length	290	mm
Weight	1.0	kg



CSCP 40	100754
CSCP 60	100755

Click pliers, large (Ø 250-315)

Length	290	mm
Weight	1.1	kg

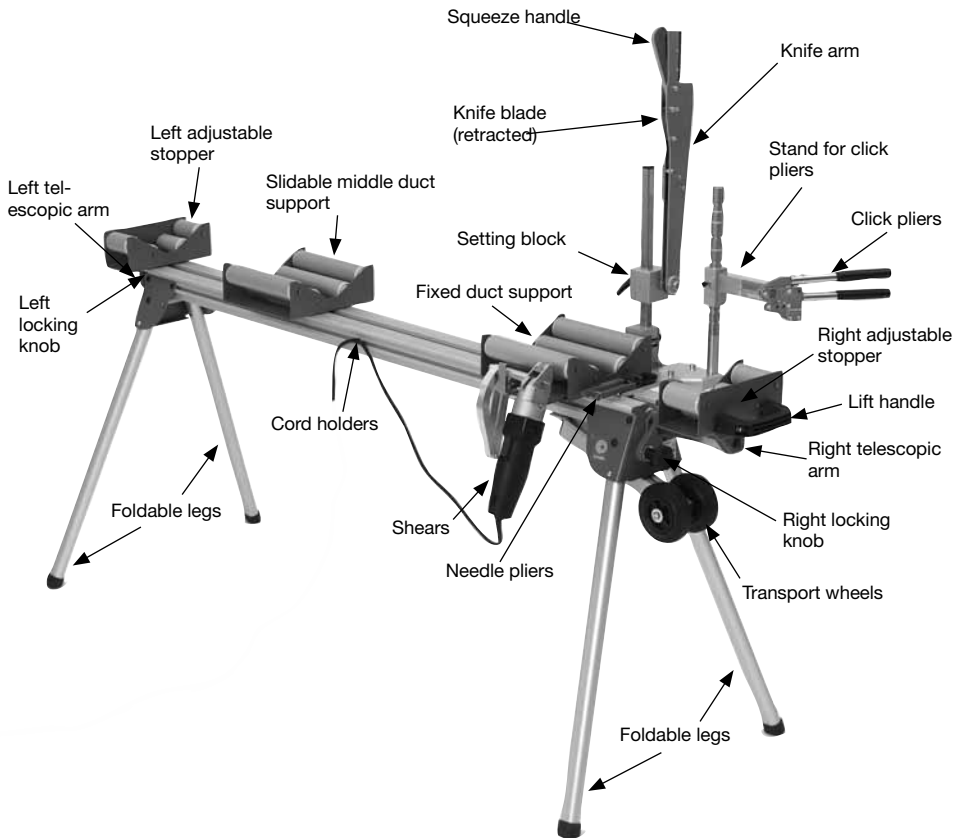
Stand for click pliers

Length	440	mm
Weight	4.5	kg



CSCPS	226617
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Presentation



With this workbench you can cut ducts of 80-315 mm diameters and lengths of 200-3000 mm.

The bench is equipped with:

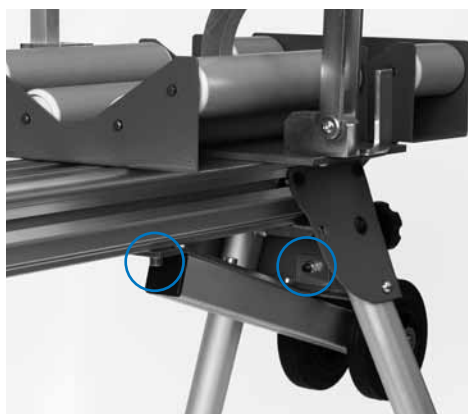
- wheels and foldable legs so you can easily move it to wherever you are currently installing ducts
- scale for setting the desired duct length
- knife to make a hole for the shears
- shears to cut the duct
- pliers to cut the inner and outer needle
- pliers to make the notches

Lubrication points

Lubricate these points with thin oil when necessary. It is important that lubrication is carried out.



Mount the wheel set



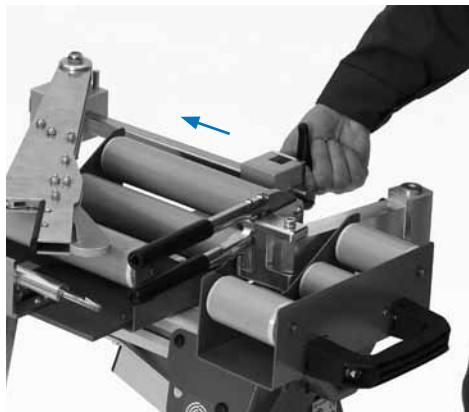
Preparations for cutting

Fold out the bench

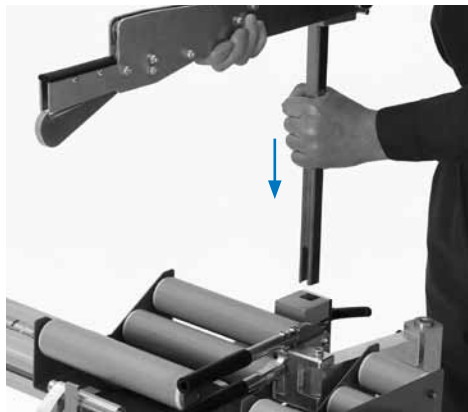


1. Lift the bench opposite the wheel side.
2. Press in the buttons and turn out the legs.
3. Lift the bench by the handle on the wheel side.
4. Press in the buttons and turn out the legs.

Open the knife stand



1. Loosen the locking handle on the knife stand.
2. Take the stand out of its horizontal position.



3. Move the stand to its vertical position.
4. Tighten the locking knob.

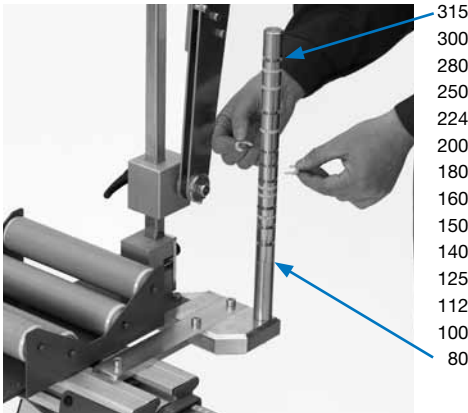
Mount the click pliers set (accessory)



1. Push the rectangular washer into the dovetail groove.



2. Secure the two screws.
Tighten all three screws.



3. Block the grooves for the dimensions which are not used with the clip.

Install the arm



1. Pull out the small locking knob.
2. Fit the arm over the stand and let the locking knob engage.



Mount the click pliers onto the arm.

Mount the shears



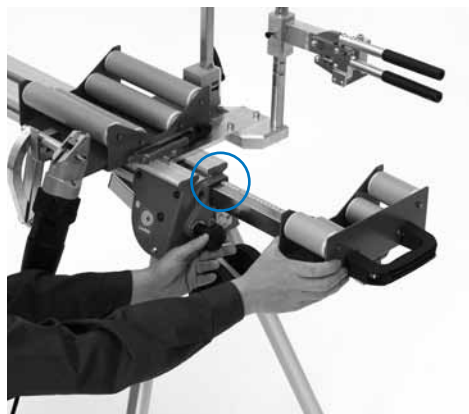
1. Take the shears over the split pin so the pin locks.



2. Hang the cables in the cable holder.

Instructions for cutting

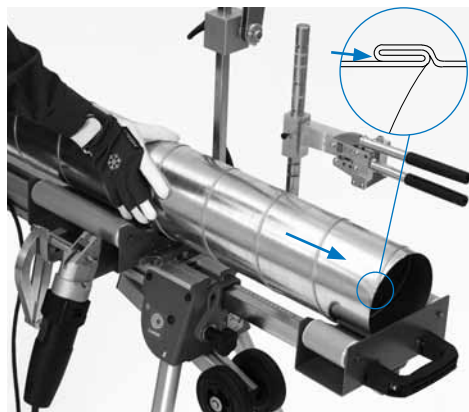
Set the desired duct length



1. Loosen the telescopic arm's locking knob.
2. Set the desired duct length on the scale.
3. Tighten the locking knob

For lengths of 200-1700 mm use the right telescopic arm and for lengths of 1700-3000 mm use the left telescopic arm.

Position the duct



1. Turn the duct so that the opening of the fold is facing you.
2. Place the duct on the bench.
3. Push the end of the duct towards the stopper on the telescopic arm.



4. Adjust the slidable middle duct support so it is as close as possible to the duct end.

Adjust the knife arm so that it matches the duct's diameter



1. Loosen the locking handle on the setting block.
2. Move the block so that the arm is horizontal when it hits the duct.
3. Tighten the locking handle.

Make a hole with the knife



1. Squeeze the handle right down so the knife's edge comes out.
2. Rotate the duct so the knife hits the duct a bit "before" the duct's spiral fold.
3. Hold the duct with one hand.
4. Press the knife arm firmly downwards until the knife arm stopper touches the duct.

Scratch a line with the knife



1. Scratch a thin line with the point of the knife around the duct. The easiest way to do this is turning the duct away from you. Use the scratched line as a guide to cut straight.

Cutting the duct with the shears



1. Start the shears.
2. Insert the shears' cutting tooth into the hole.
3. Turn the duct almost one full turn towards you. Make sure the scratched line is in the centre of the strip that is cut off.



4. Do not turn the last bit but hold the duct still and lead the shears forward instead.

NOTE: If you experience problems passing over the fold or to do with cutting ducts straight, see the "Problem solving" chapter.

Cutting the outer needle



Lindab recommends cutting the outer needle from Ø 100 and bigger.

Cutting the inner needle



Lindab recommends cutting the inner needle from Ø 315 and bigger.

Use the correct click pliers to get the notch at the right distance from the duct end



Use the 40-pliers for Ø 80-224 (Ø 3"-9").
Use the 60-pliers for Ø 250-315 (Ø 10"-12").

Adjust the click pliers' arm so the height of the click pliers arm matches the duct's diameter



1. Pull the locking pin knob out. (The knob can be locked in its outer, free position by twisting it.)
2. Move the block to a suitable groove.
3. Let the knob spring back in to lock the block.

Making notches



For the recommended number of notches, see "Assembly Instructions Lindab Safe and Lindab Safe Click".

1. Insert the opening of the pliers over the duct end as far as it can reach.
2. Keep in place by holding the duct with your



- other hand.
 3. Press the handle fully together.
 4. To control the notch, see the instructions for "Checking the notch".
 5. Place the notches evenly around the circumference.
- You can easily loosen the pliers from the arm for separate use.

Moving the bench



1. Move the click pliers down between the fixed duct and the right-hand duct support.
2. Push the right telescopic arm in and lock the knob.
3. Push the slidable middle duct support to the right – up to the fixed duct support.
4. Lower the knife arm.
5. Hold onto the handle and turn in the legs on the wheel side.
6. Move the bench as shown in the picture.
7. Use a high grip, with the bench in a vertical position, to get it through narrow passages.

Fold the bench as small as it will go e.g. for stowing in a car.

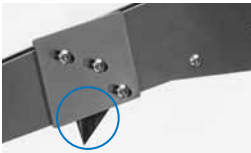

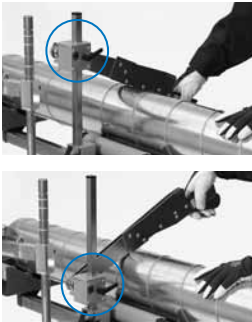
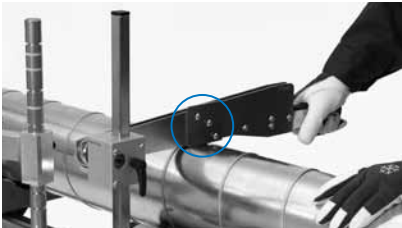


1. Loosen the top part of the click pliers stand.



2. Place the stand as shown in the picture.
3. Collapse the knife stand.
4. Turn the legs in.

Problem solving

Problem	Cause	Solution
The knife is difficult to press through the duct.	 <p>The knife is blunt.</p>	<p>Remove and sharpen the knife or replace it with a new one.</p>  <p>After sharpening, make sure you adjust the stopper so that the knife enters far enough to make a large enough hole.</p>
	 <p>The knife arm is set at an incorrect height.</p>	<p>Choose the correct height for setting the knife arm.</p>  <p>The arm must be as horizontal as possible when its stopper hits the duct.</p>

Problem

Cause

Solution



The cutting tooth of the shears cannot enter the knife hole.



The tooth does not hit the hole.

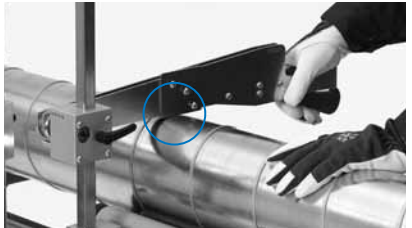


Tip: Check that the edge of the knife touches the centre of the shears' tooth.



The hole is too small.

The knife arm's stopper was not pressed all the way down to the duct when the hole was made.

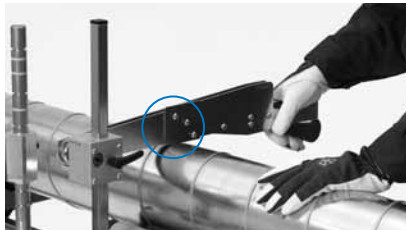


Press the stopper all the way down to the duct.



The hole is too small.

The knife arm is set at an incorrect height.



Choose the correct hole for setting the knife arm.

The arm must be as horizontal as possible when its stopper hits the duct.

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Problem

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(The cutting tooth of the shears cannot enter the knife hole.)

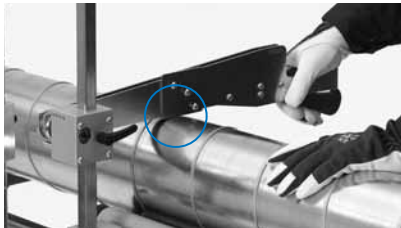
Cause

The hole is too small.





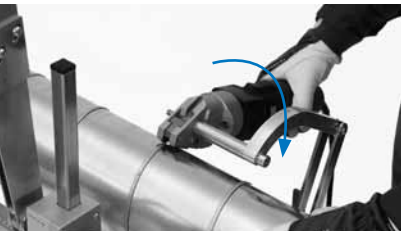
The stopper of the knife arm was set incorrectly e.g. after sharpening the knife.

Solution



Adjust the stopper so that the knife goes in to make a large enough sized hole.



Problem	Cause	Solution
The duct is difficult to cut with the shears.	The shears are blunt.	Remove the cutting tooth of the shears and replace it with a new one. (After very heavy wear the side cutter may also need to be replaced.) See the chapter on spare parts.
	The opening of the fold is turned away from the shears.	Turn the duct so that the opening of the fold is facing the shears.
The fold is difficult to cut with the shears.	The knife hole was made in the wrong place.	 <p data-bbox="609 719 990 767">Make the knife hole in the place, i.e. just before the fold.</p>
	The shears are blunt.	Remove the cutting tooth of the shears and replace it with a new one. (After very heavy wear the side cutter may also need to be replaced.) See the chapter on spare parts.
	The wrong work method is being used.	 <p data-bbox="609 1174 990 1222">Press the shears forward a bit harder but make sure you work them upwards...</p>  <p data-bbox="609 1477 710 1503">and down.</p>

Problem

Cause

Solution



The bearing pivots points for the shears or knife are too loose.



Tip: Check that the edge of the knife touches the centre of the shears' tooth.



The duct was not cut off properly and has a nick.

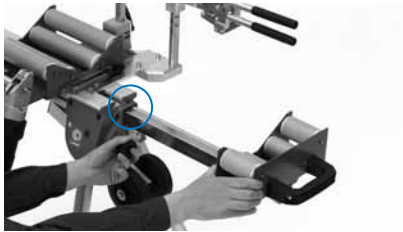
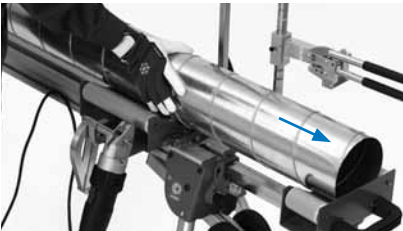
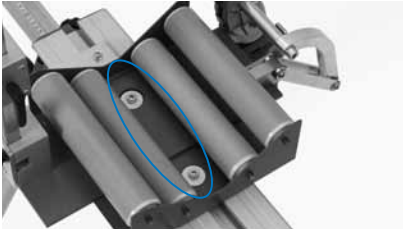
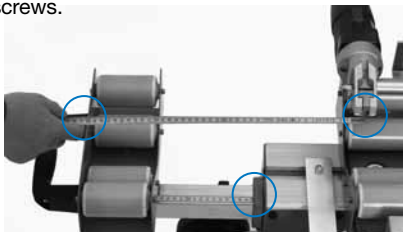


The shears were forced to the left or right during cutting.



Tip: Before cutting, scratch a thin line with the point of the knife around the duct. Make sure the scratched line is in the centre of the strip that is cut off.



Problem	Cause	Solution
The cut duct is the wrong length.	The scale is set to an incorrect length.	 <p data-bbox="609 512 902 536">Set correct length on the scale.</p>
	During cutting, the duct was not pressed close enough to the stopper at the end of the telescopic arm.	 <p data-bbox="609 807 941 831">Press the duct close to the stopper.</p>
	The fixed duct support has come loose from the bench.	 <p data-bbox="609 1110 964 1158">Fix the support with its two tightening screws.</p>  <p data-bbox="609 1390 1023 1520">Make sure that the free distance between the closest edge of the shears' cutting tooth corresponds with the marking on the scale. NOTE: Applies to both right and left stoppers.</p>

Problem

Cause

Solution



The cut duct has a nick at the knife hole.



The hole is too wide.



Adjust the stopper so that the knife goes in far in enough to make a large enough hole.

The click pliers make holes in the duct.



The pliers' stop screw has been screwed in too far.

Unscrew the stop screw slightly. Check how the notch looks, see instructions for "Checking the notch".

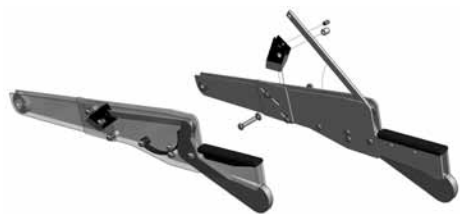
The click pliers make a faint notch.



The pliers' stop screw has been unscrewed too far.

Screw the stop screw in slightly. Check how the notch looks, see instructions for "Checking the notch".

SR Cutter



Working bench
SRCS 226601
SRCS US 100584

Spare parts



Roller (100)
CSPR 100 226605



Roller (250)
CSPR 250 226606



Duct support 250 with
rollers 250
SRCR 250 101249



Handle with duct
support 100
SRCH 100772



Shears stand with pin
for Dräco
CSSA 101168



Pin for Dräco
CSSAA 101246



Knife arm with knife
stand
SRCKA 100765



Knife
CSKE 226612

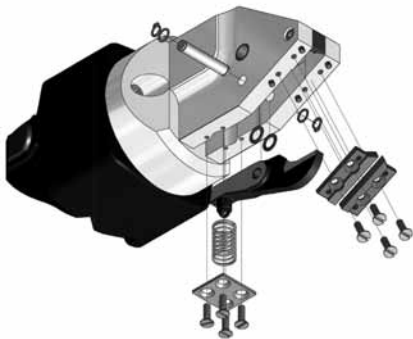


Wheel kit
SRW 100156



Leg shoe
SRCSF 101248

Shears (Dräco 3514-7R)



Shears		
CSS EU 230		226607
CSS UK 110		226609
CSS CH 230		226608
CSS US 110		100886

Spare parts



Shears cutting tooth
37140

CSSK 226611



Pin set for shears
cutting tooth 37140

CSSKPS 100146



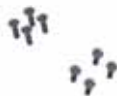
Shim set for shears cutting
tooth 37140

CSSSSS 100147



Side cutting edges
for shears

SJS 226623



Screw and pin set

SSPS 100002

Click pliers



- Click pliers
- CSCP 40 100754
- CSCP 60 100755

Spare parts



- Gauge
- CSNC 100096



- Adapter for click pliers
- CSCPA 100756

Stand for click pliers



Stand
CSCPS 226617

Spare parts



Clips
CSCPSC 101488

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